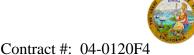
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-011140 Address: 333 Burma Road **Date Inspected:** 13-Dec-2009

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai

CWI Name: ZPMC and ABF **CWI Present:** Yes No N/A **Inspected CWI report:** Yes **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** OBG

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay#5

Traveler rail: - Caltrans QA inspector observed six ZPMC welders performed FCAW process on the flange to web plate of traveler rail #10TR6-002, 11TR6-002, 11TR9-002, 11TR3-001, 11TR6-002 and 11TR9-001. This type component designed has CJP and PJP weld along on one side of full weld length and other side has CJP only. All the welding areas have been pre heating prior FCAW welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Traveler rails: - Caltrans QA inspector observed a welder performed carbon arc back gouging process on the flange to web plate of traveler rail. A back gouging is on one side of flange to web of two traveler rails # 11TR1-016 and 11TR1-017. Approximately 8mm sound wall thick has been gouged out. The back gouging area has been re-bevel to request design joint by grinding and the beveled surface is entirely free of the scale, traces of oxide films and other contaminants prior welding. Base on Caltrans observation, no discrepancies were noted.

Traveler rail: - Caltrans QA inspector observed two ZPMC workers performed grinding process on the angle plates with 200 lengths. The grinding is removing approximately 6mm x 6mm from the top corner of angle plate as design drawing. The angle plates are attaching to central of traveler rails and cover a size 4mm fillet weld. The grinding process was monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI

WELDING INSPECTION REPORT

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observation, no discrepancies were noted.

Bike path: - Caltrans QA Inspector observed two welders performed FCAW process on CJP welds for exterior plates of bike path cantilever beam. The bike path cantilever beam ID is BK-001-033-1 and BK-001-033. During observation, ABF QC informed Caltrans QA inspector that between the end plate and exterior plates of bike path cantilever beam has been changed use PJP weld in lieu of CJP weld but the weld joint remained with backing bar and the RFI file number is RFI # ABF-RFI-001933-R02 The FCAW welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Bay #6

Tower strut: - Caltrans QA Inspector performed QA final VT, MT and UT test on the CJP welds and fillet welds of tower strut. The strut welds ID are WD1-A305-53M-3-1A/B, WD1-A305-53M-3-2A/B, WD1-A305-53M-3-20~31, WD1-A305-53M-3-10~19/58/59 and WD1-A305-53M-3-32~43. All the CJP welds have been accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans VT, MT and UT inspection, the CJP welds and fillet welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





Summary of Conversations:

As notes within report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

| Inspected By: | Pau,Wai | Quality Assurance Inspector |
|----------------------|------------------|-----------------------------|
| Reviewed By: | Clifford,William | QA Reviewer |